Work Order ID 113079

February-12-14 8:15:39 AM

113079

Item ID: D2810-5 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Strut

Start Date: 2/21/14 **Start Qty:** 4.00 *4*

Required Date: 2/21/14 **Req'd Qty:** 4.00 *4*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLJ **Date:** 14-02-13 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
D2810	Rev C

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	NC BRAKE	0.00				4			14-03-13
100									
Brake NC	**Memo**	0.00							
Brake NC	1-Punch 304/316 SS Seamless Tubing 0.5" O.D. x 0.035" wall to length as per Dwg D2810 and spec control Dwg D2727 using Jig DT8012 2-Deburr								
110	QC5- Inspect part completeness to step on W/O	0.00				4			
110									
QC	**Memo**	0.00 14/3/14							
Quality Control									
120	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00				H. Ø			
120	M126898					14-3-14			
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 11.00 OVEN TEMPERATURE: 200° FINISH TIME: 11.30								

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Work Order ID 113079

February-12-14 8:15:39 AM

113079

Item ID: D2810-5 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Strut

Start Date: 2/21/14 **Start Qty:** 4.00 *4*

Required Date: 2/21/14 **Req'd Qty:** 4.00 *4*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00 DAS 27 9-89				4			
130 QC Quality Control	**Memo**	0.00 14/3/11							
140	Identify as per dwg & Stock Location: ST254	0.00							DAS 26 9-89
140 Packaging Packaging	**Memo**	0.00				4X		14-3-11	
150	QC21- Final Inspection - Work Order Release	0.00							
150 QC Quality Control	**Memo**	0.00				MLO 14-03-11			
						(M) 14.03.11			

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Over/Under tolerance
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☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Picklist Print

February-12-14 8:15:44 AM

Work Order ID: 113079

113079

Parent Item: D2810-5

D2810-5

Parent Item Name: Strut

Start Date: 2/21/14 **Required Date:** 2/21/14

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP A04.11.30New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	219.1999	1.9175	8.073684			

M304TR0.500W.035

304 RD Tube .500 x .035W

**

FF 14-03-09

Location	Loc Qty	Loc Code	
MAT017	219.1999		
125513	16.1999		
m126922	3		
m128084	200		8.073

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

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Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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Landing Gear

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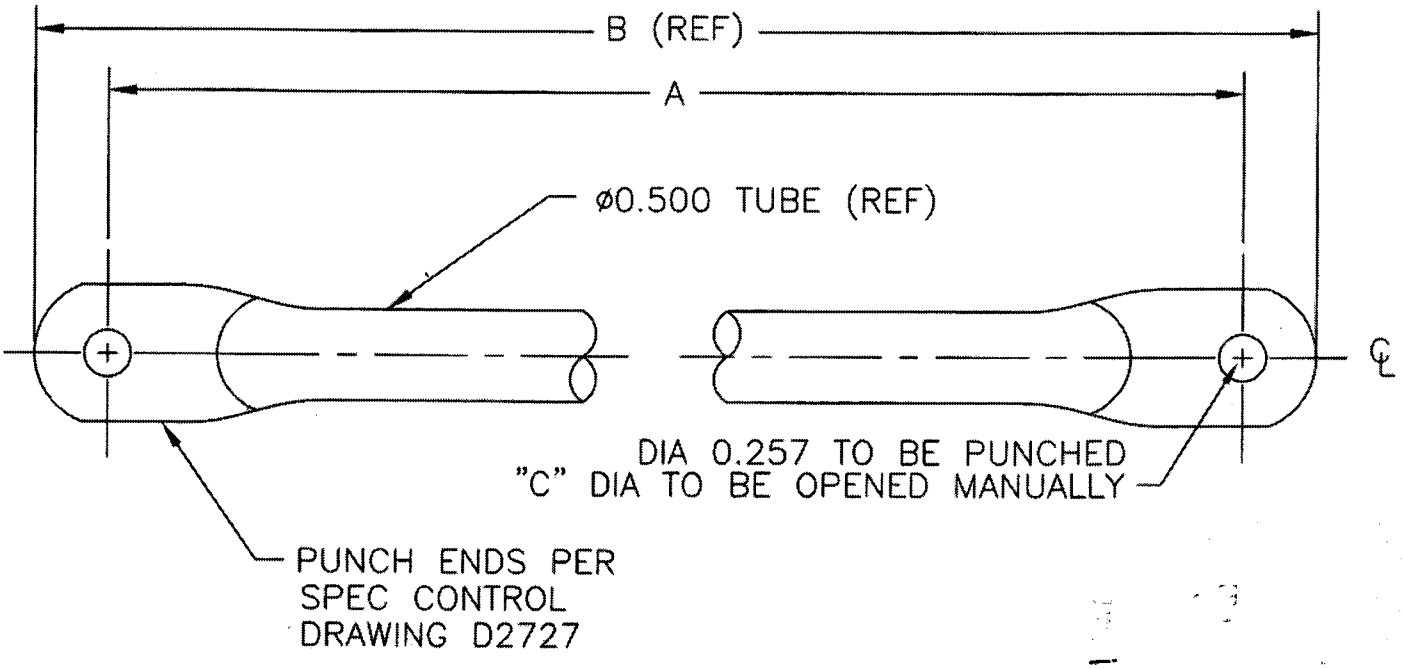
General

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☐ Burrs
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☐ Countersink
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☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2810	REV. C SHEET 1 OF 1
DATE 04.11.22		TITLE STRUT	SCALE NTS

A	00.11.08	NEW ISSUE
B	03.09.11	ADD FINISH
C	04.11.22	ADD −5

RELEASED
05.03.11



PART #	A	B	C
D2810−1	25.33	26.13	N/A
D2810−3	24.60	25.40	N/A
D2810−5	23.01	23.81	0.266

113079 MCS
14-02-13

D2810−1/−3/−5

1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, ø0.500 x 0.035 WALL (M304TR0.500W.035)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
4) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD

Description:	Strut	Work Order:	113079
Inspection Drawing:	D2810	Rev: C	Part Number: D2810-5

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A: 23.01	± 0.030	23.01	✓		SFab-07	
B: 23.81	± 0.030	23.81	✓		SFab-07	
ϕ .266	± 0.030	.266	✓		SFab-14	

Measured by:	Checked By: DAS 30 9-89	QC inspector DAS 27 9-89	Engineering Approval *(if necessary)*:
FF			
Date 14-03-10	Date 14/03/10	Date 14/3/10	Date